

54696 Deriv.

Work Order ID 48169



Page 1

June 26, 2009 7:30:55 AM

Item ID: D3684-049

Accept



Setup Start



Revision ID: C

Stop



Item Name: AFT LEG ASS'Y

Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *mk*

Date: 09-09-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3684

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

09/12/14

4 6

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 112-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684.***Ensure holes for AN3C Bolts are free of sealant

09/12/14

4 2

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

09/12/15

04

Work Order ID 48169

June 26, 2009 7:30:55 AM



Page 2

Item ID: D3684-049

Accept



Setup Start



Revision ID: C

Stop



Item Name: AFT LEG ASS'Y

Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>ST 136</i>	0.00							
Packaging	Memo	0.00				<i>X4</i>			
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/12/17 AJ

MF 09-12-14

Picklist Print

June 26, 2009 7:30:54 AM

Page 1

Work Order ID: 48169

Parent Item: D3684-049RevC

Parent Item Name: AFT LEG ASS'Y









Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN3C12A 		Purchased	No			110	Each	0.0000	8.0000			
Bolts ✓ D3688-3RevB 		Manufactured	No			110	Each	0.0000	4.0000			
* ✓ STUD D3689-1RevB 		Manufactured	No			110	Each	0.0000	4.0000			
* ✓ SLEEVE D3691-1RevU/R 		Manufactured	No			110	Each	0.0000	4.0000			
* ✓ STUD D3692-1RevB 		Manufactured	No			110	Each	0.0000	16.0000			
* ✓ SPACER D3693-1RevU/R 		Manufactured	No			110	Each	0.0000	4.0000			
Rod End Bearing ✓ MS21043-3 		Purchased	No			110	Each	0.0000	8.0000			
Nut ✓ NAS509L12C 		Purchased	No			110	Each	0.0000	4.0000			
Nuts												

M110584

SB 08/12/14

B45671(2)

B50936(2)

4850740

SB 08/12/14

~~B45671~~ B51772

SB 08/12/14

SK B50736

SB 09/12/14

B50734

SB 09/12/14

M111819

SB 09/12/14

M110844

SB 09/12/14

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
		Add Missing Part Nas 50912C (copy attach on back) perm. change	AA	10/01/04	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:46:28 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT LEG ASS'Y
Job Number	: 48169		
Estimate Number	: 13176		
P.O. Number	:	Part Number	: D3684049
This Issue	: 22/05/2009 S.O. No. :	Drawing Number	: D3684 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 45601	Material	:
Written By	:	Due Date	: 29/05/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>JLD 09.05.25</u>		
Comment	: Est Rev:A new issue 08-02-12 DD verified by:JLM : Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC : Est Rev:C Added sealant note as per Rev C 09-01-20 JLM : Verified By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 ✓	PACKAGING 1	PACKAGING RESOURCE #1
-------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

2.0 ✓	D36883	STUD
-------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

STUD

batch B 515 671 ⑦B 509 36 ②

JS 09/12/11

3.0 ✓	D36891	SLEEVE
-------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

SLEEVE

batch B 507 45

JS 09/12/11

4.0 ✓	D36911	STUD
-------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

STUD

batch B 517 72 ④

JS 09/12/11

5.0 ✓	D36921	SPACER
-------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

SPACER

batch B 507 36

JS 09/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:46:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT LEG ASS'Y

Job Number: 48169

Part Number: D3684049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

✓

D36931

Rod End Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rod End Bearing

batch 50734

SB 09/12/11

7.0

✓

AN3C12A

Bolts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolts

batch M110584

SB 09/12/11

8.0

✓

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch M111519

SB 09/12/11

9.0

✓

NAS509L12C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nuts

batch M110844

SB 09/12/11

10.0

NAS50912C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nuts

batch M112153

SB

11.0

✓

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3684

SB 09/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:46:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT LEG ASS'Y

Job Number: 48169

Part Number: D3684049

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: _____

14.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

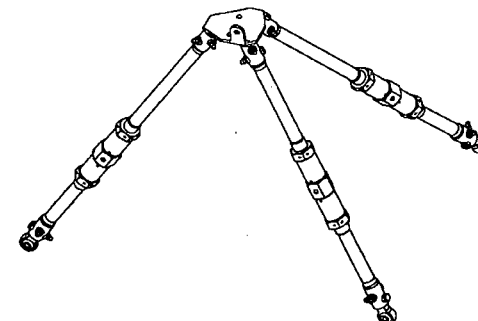
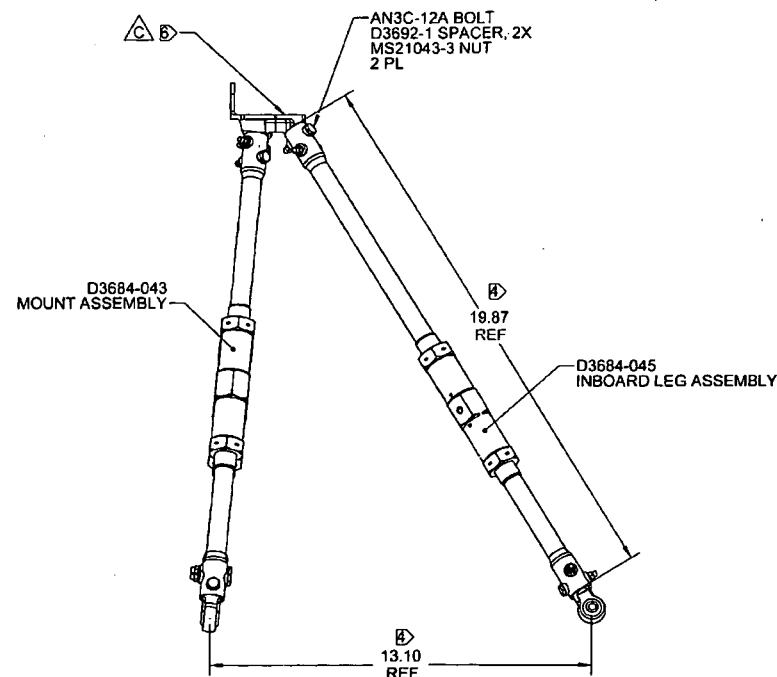
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3684-041	TRIPOD MOUNT ASSEMBLY
2	1	D3684-043	MOUNT ASSEMBLY
3	1	D3684-045	INBOARD LEG ASSEMBLY
4	4	D3692-1	SPACER
5	2	AN3C-12A	BOLT
6	2	MS21043-3	NUT



RELEASED
08/12/15

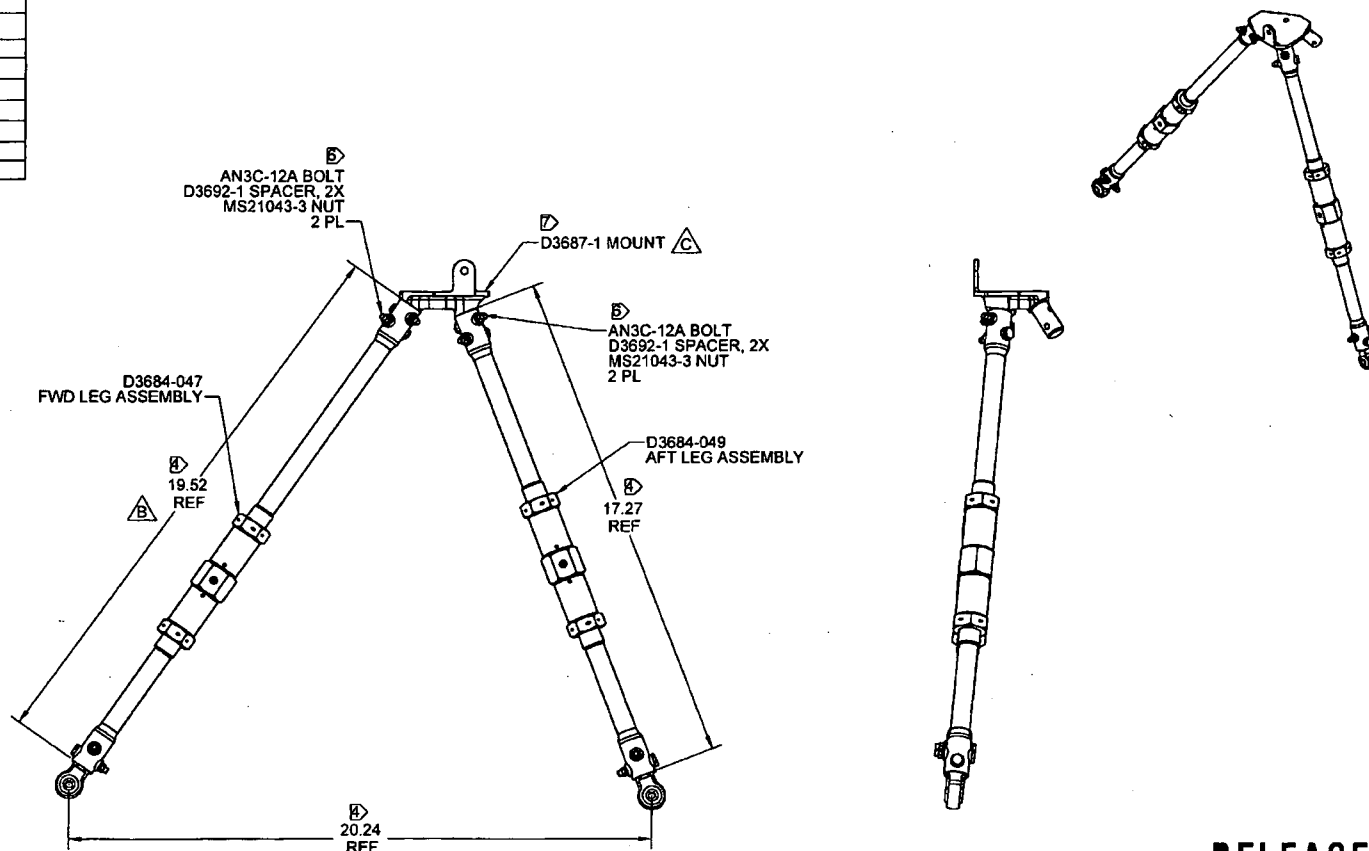
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, D6-1, A8-2, D4-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5); ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1)	RF	08.12.15
B	19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C5-2); 20.74 WAS 21.24 (ZN C5-4); 6.95 WAS 6.88 (ZND5-5); MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3684	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3/5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 9.9 lbs
- 6) ASSEMBLE D3684-045 WITH D3684-043 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT
- 7) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED

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WORK ORDER
NO. 178109

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3684-043 MOUNT ASSEMBLY

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WORK ORDER
NO. 178169

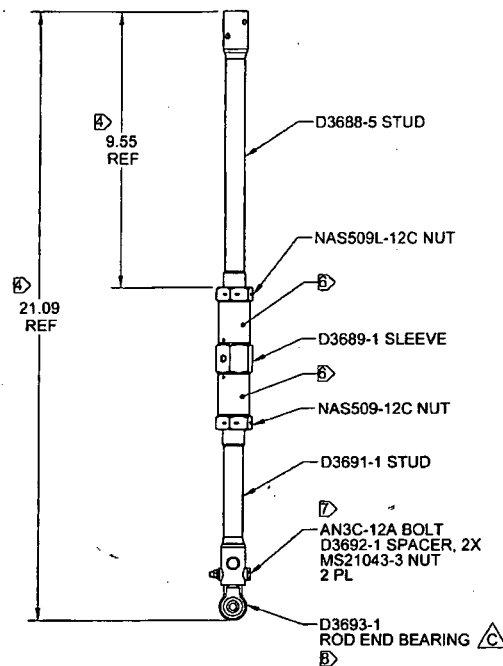
RELEASED
09/07/12

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. C
MFG. APPR.	21	D3684	SHEET 2 OF 5
APPROVED	16	TITLE	SCALE
DE APPR.	16	TRIPOD MOUNT ASSY	NTS
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-045 INBOARD LEG ASSEMBLY

RELEASED
09/01/12 MIP

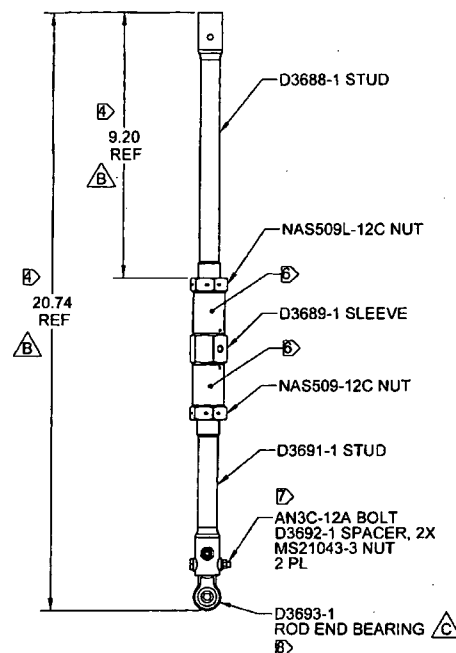
NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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17/01/12

ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT





D3684-047 FWD LEG ASSEMBLY

RELEASED
09/01/12

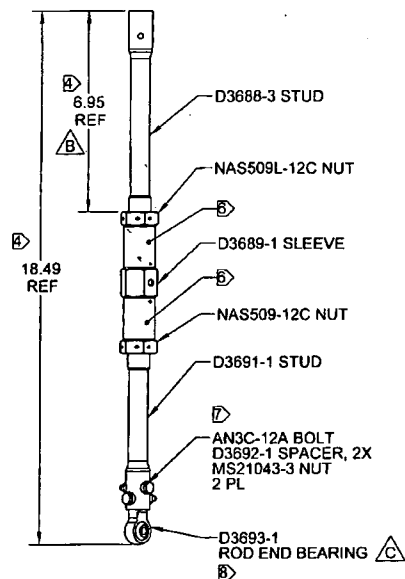
NO. 17810
WORK OFFICE
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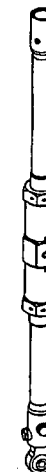
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.10 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY



NO. 10
B
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NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX 241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
09/01/15

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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Status	Item ID	Rev	Name	Start Date	Quantity	Pe	UOM	Scrap %	Route Seq	IC	Sort	Date Last Mod	Add Date	Comments
<input checked="" type="checkbox"/>	NAS509-12C		Nuts	12/08/2009	11.0000		Each	0 %	110		0	05/12/2009 7:0...	05/12/2009	
<input checked="" type="checkbox"/>	D3693-1		Rod End Bearing	05/12/2009	1.0000		Each	0 %	110		0	05/12/2009 7:0...	05/12/2009	
<input checked="" type="checkbox"/>	NAS509L12C		Nuts	01/01/2008	1.0000		Each	0 %	110		0	05/12/2009 7:0...	05/12/2009	
<input checked="" type="checkbox"/>	D3691-1		STUD	05/12/2009	1.0000		Each	0 %	110		0	05/12/2009 7:0...	05/12/2009	
<input checked="" type="checkbox"/>	D3688-3		STUD	05/12/2009	1.0000		Each	0 %	110		0	05/12/2009 7:0...	05/12/2009	
<input checked="" type="checkbox"/>	AN3C12A		Bolts	01/01/2008	2.0000		Each	0 %	110		0	05/12/2009 7:0...	05/12/2009	
<input checked="" type="checkbox"/>	D3689-1		SLEEVE	05/12/2009	1.0000		Each	0 %	110		0	05/12/2009 7:0...	05/12/2009	
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<input checked="" type="checkbox"/>	MS21043-3		Nut	01/01/2008	2.0000		Each	0 %	110		0	05/12/2009 7:0...	05/12/2009	